

Date: Monday, 12/12/2005 1:29:49 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET
Job Number	: 25205		
Estimate Number	: 10035		
P.O. Number	: N/A	Part Number	: D6101007
This Issue	: 12/12/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D6101 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24893	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 12/21/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	30
Comment	: Est. A: 01.05.04 New Issue EC	Um:	Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Issue P/O:

273

a) Description: Alluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

u 25-12-12

2.0

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

7075-T7351 8.25X7.75X2.5

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 205/12/22 30

4.0

QC6

DIMENSIONAL CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

RG 06.01.16 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/12/2005 1:29:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25205

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CY 06/01/16 30

6.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

5.15 06/01/17 (30) 06/01/17 (30)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131					
SOLD TO: AM CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131					
CUSTOMER PO NUMBER: 01-81306		CUSTOMER PART NUMBER: 6879		SHIPPING RUN #/LOAD ID: 100550/15	
KAISER ORDER NO: 1027000		LINE ITEM: 1		SHIP DATE: 8-DEC-2005	
WEIGHT SHIPPED: 7204 LB		QUANTITY: 4 PCS EST.		B/L NUMBER: 206775	
ALLOY: 7075		CLAD: BARE		TEMPER: T7351	
GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

**KAISER
ALUMINUM**
 Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4055054

Certified Specifications

AMS 4078/RevF
 ASTM B 209/Rev04
 BSS 7055/RevA
 GSS16100/RevG
 PS 21211/RevJ

AMS-QQ-A-250/12
 ASTM B 594/Rev02
 CSTI 006/RevB
 MIL-STD-2154

AMS-STD-2154
 BAC 5439/RevH
 DPS 4.713/RevN/AmdAF
 MMS 159/RevN

Test Code: 4297

Test Results

Lot: 343354A7 Cast 861 Drop 48 Ingot 1

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	71.0 : 71.3 (490 : 492)	59.6 : 60.2 (411 : 415)	10.0 : 10.6
		Conductivity %IACS :	40.6 Min	40.7 Max	
		(MS/M) :	23.5 Min	23.6 Max	

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.12	0.25	1.50	0.05	2.46	0.19	5.73	0.04	0.01	0.02	TOT 0.02

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP

DATE REC'D 12/12/05 SAC 6879

APPROVED BY: SCU

KAISER ALUMINUM

**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586**

CERTIFIED TEST REPORT

**Serial Number
4055054**

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

